

Work Order ID 150790

Tuesday, September 06, 2016 2:00:29 PM

150790

Page 1

Item ID: D5235-044 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: RH Step Assembly
Start Date: 9/6/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/13/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: DAS 21 9-09 Date: SEP 06 2016 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5235	B	PK							

110

110

Small Fab

Small Fab

Memo

1- ASSEMBLE FIXTURE DT10150 WITH BLOC "A", "B" AND "C" TO
MANUFACTURE D5235-044.

2- ASSEMBLE D5273-043 FITTINGS TO D5274-3 STEP WITH PROSEAL
AS PER DWG
A/R PROSEAL: 135390

3- INSERT ALL PARTS TOGETHER IN FIXTURE DT10150 AND
TRANSFER DRILL HOLES USING DT10186 FOR D5271-1/-4 AND DT
10185 FOR D5271-1 AS PER DWG AND NOTES 9,10.

4- DISASSEMBLE AND DEBURR.

5- a) USE DT10170 DRILL JIG TO DRILL NUT PLATE HOLES IN D5272-1/-
3 TUBE AS PER DWG.
b) DEBURR
c) TOUCH UP HOLES WITH ALODINE ONLY
d) INSTALL NUTPLATES IN TUBES

6- TOUCH UP HOLES WITH ALODINE ONLY ON D5271-1/-3 AND D5273-
041 FITTINGS.

7- USE DT10150 TO RE-ASSEMBLE REST OF THE PARTS TOGETHER
USING PROSEAL AS PER DWG
A/R PROSEAL: 135390

SEP 06 2016

Pto

DAS
26
9-09

16/09/08

DQA: duf Date: 2016-10-7



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: ROH Date: OCT 03 2016

Work Order update only ☐

Work Order: <u>158,90</u> Part No. <u>D5272-1</u> NCR No. <u>16-6072</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☒</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Date: <u>16-09-08</u>	Step #: <u>110</u>	QTY Effective: <u>1</u>	MRB (QSI042) Approval DAS 9 9-89 <u>16-09-09</u>																																																																	
Description Work Order Deviation		Disposition		Completed By: DAS 36 9-89 <u>16/09/08</u>																																																																
One piece is scrap, the tubing wasn't deep enough in the bracket so the hole was too close to the edge. <u>D5272-1</u> <u>B140318</u>		<u>SCRAP + Destroy</u> <u>replace</u> <u>D5272-1 B140318</u>		Lead hand / Supervisor Approval Verification DAS 30 9-89 <u>SEP 08 2016</u>																																																																
				QC / QA Coordinator Approval DAS 9 9-89 <u>16-09-09</u>																																																																
Root Cause <table style="width:100%;"> <tr><td>Environment ☐</td><td>No Re-verification ☐</td></tr> <tr><td>Design ☐</td><td>Operator ☐</td></tr> <tr><td>Doc/Data ☐</td><td>Offset/Setup ☒</td></tr> <tr><td>Equip/Tooling ☐</td><td>Supplier ☐</td></tr> <tr><td>Handling/Pre ☐</td><td>Training ☐</td></tr> <tr><td>Material ☐</td><td>Use for Testing ☐</td></tr> <tr><td>Internal Transport ☐</td><td>Poor Information ☐</td></tr> <tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td></tr> <tr><td>LOA ☐</td><td>Product Improvement ☐</td></tr> <tr><td>Substation ☐</td><td>Process Improvement ☐</td></tr> <tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td></tr> <tr><td>Misidentified ☐</td><td>Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☒	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	FAULT CATEGORY <table style="width:100%;"> <tr> <td>Pressure/Forced ☐</td> <td>Temperature/Cure ☐</td> <td>Power Loss/Surge ☒</td> <td>Positioned Wrong ☒</td> </tr> <tr> <td>Bending ☐</td> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Centre Not Concentric ☐</td> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Cuffs ☐</td> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Crushing ☐</td> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> </table>			Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☒	Positioned Wrong ☒	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
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OTHER :																																																																				

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PAINT AS PER DWG AND QSI005 4.2.2.3
WHITE IMIRON PAINT: 135302

⑦ 1609.09 DAS
9
9-89

1

DAS
41
9-89

16-9-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
24-1 2 138-1				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 150790

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150790

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Item ID: D5235-044 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: RH Step Assembly
Start Date: 9/6/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/13/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC14- Inspect Spray Paint	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Wing Walk as per dwg QSI005 4.4 Batch	0.00							
150									
HandFinish	Memo	0.04							
Hand Finishing									
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									

DAS
15
9-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 150790***150790***

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Item ID: D5235-044 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: RH Step Assembly
Start Date: 9/6/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/13/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.02							
Quality Control									

DAS
21
9-89

SEP 22 2016

U60722

ENG07701 SEPT

Helitech
Snow
Simon

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

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Page 1

Work Order ID: 150790

150790

Parent Item: D5235-044

D5235-044

Parent Item Name: RH Step Assembly

Start Date: 9/6/2016

Required Date: 9/13/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 15.12.15 NEW ISSUE DD VERF:JLM IPP
REV:B AS PER REV B 16.03.11 JLM VERIFIED BY:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

CR3212-4-5		Purchased	No				Each	458.0000		28			
CR3212-4-5									**				
Cherry Rivet													

Location	Loc Qty	Loc Code
CCK003	200	
m134654	100	
m134962	100	
ST320	258	
m134537	100	
m134574	158	

D5271-1		Manufactured	No				Each	20.0000		1			
D5271-1									**				
Forward Fitting													

Location	Loc Qty	Loc Code
ST226b	20	
140320	14	
145628	6	

D5271-4		Manufactured	No				Each	17.0000		1			
D5271-4									**				
RH Aft Fitting													

Location	Loc Qty	Loc Code
ST227	17	
140040	17	

SEP 06 2016

Picklist Print

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Work Order ID: 150790

150790

Parent Item: D5235-044

D5235-044

Parent Item Name: RH Step Assembly

Start Date: 9/6/2016

Required Date: 9/13/2016

Start Qty: 1.00

Required Qty: 1.00

D5272-1

Manufactured No

Each

14.0000

1

D5272-1

Fwd Tube

**

16/09/06

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

14

140318

14

Each

14.0000

1

Manufactured No

**

16/09/06

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

14

140815

14

Each

28.0000

2

Manufactured No

**

PL

D5273-043

D5273-043

End Fitting Assembly

Location

Loc Qty

Loc Code

ST227A

28

140321

24

146831

4

Each

0.0000

1

Manufactured No

**

16/09/06

DAS
36
9-89

Location

Loc Qty

Loc Code

ST161

90

144620

50

146802

40

ST162

63

140319

63

14

Manufactured No

**

PC

D5274-3

D5274-3

Step Extrusion

D5291-041

D5291-041

Radius Block Assembly

B 140325 (20) **

Each

153.0000

14

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 150790

150790

Parent Item: D5235-044

D5235-044

Parent Item Name: RH Step Assembly

Start Date: 9/6/2016

Required Date: 9/13/2016

Start Qty: 1.00

Required Qty: 1.00

MS24694-S98

Purchased

No

Each

215.0000

14

MS24694-S98

PC

Screw

Location

Loc Qty

Loc Code

over006

150

m134502

150

ST283

65

m134134

65

14

MS24694-S50

Purchased

No

Each

319.0000

10

MS24694-S50

PC

Screw

Location

Loc Qty

Loc Code

GA

37

m134370

37

ST284

282

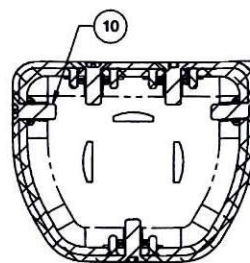
m134502

282

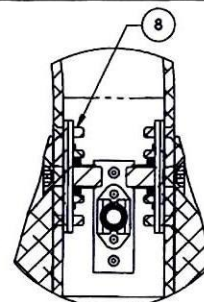
10

SEP 06 2016

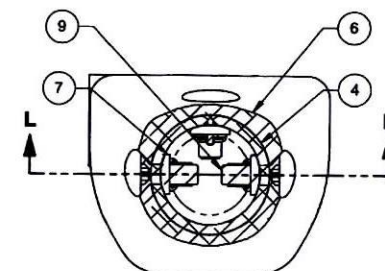
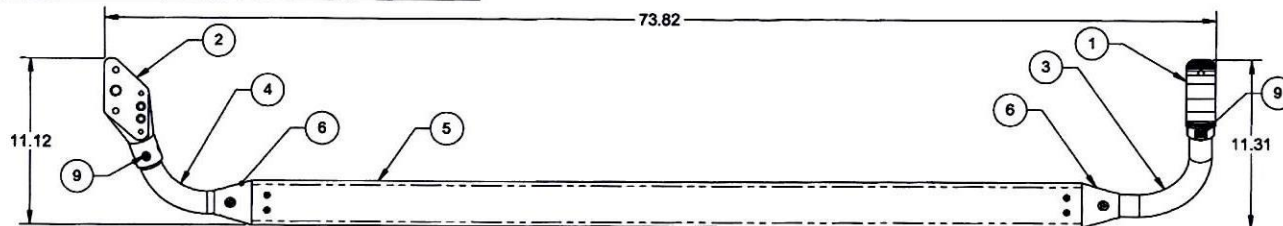
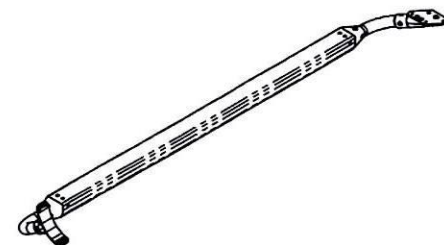
ITEM	QTY. -044	P/N	DESCRIPTION
	X	D5235-044	RH STEP ASSEMBLY
1	1	D5271-1	FORWARD FITTING
2	1	D5271-4	RH AFT FITTING
3	1	D5272-1	FORWARD TUBE
4	1	D5272-3	AFT TUBE
5	1	D5274-3	STEP EXTRUSION
6	2	D5273-043	END FITTING
7	14	D5291-041	ANCHOR NUT ASSEMBLY
8	28	CR3212-4-5	RIVET
9	14	MS24694-S98	SCREW
10	10	MS24694-S50	SCREW



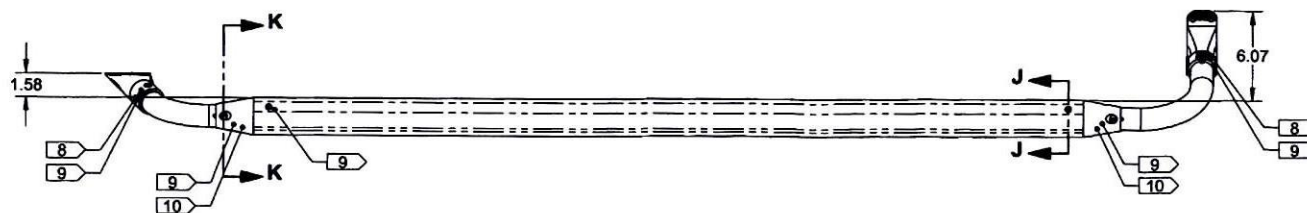
SECTION J-J



SECTION L-L



SECTION K-K



D5235-044 RH STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME AND PAINT PER DART QSI 005, SECTION 4.2, PAINT COLOUR WHITE
APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE OF STEP PER QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5235-044" PER QSI 044 6.1
- 7) WEIGHT: 8.65 lbs
- 8) ASSEMBLE WITH PROSEAL 890 USING FIXTURE DT10150
- 9) TRANSFER DRILL FROM D5271-1/4 TO D5272-1/3
- 10) TRANSFER DRILL FROM D5273-043 TO D5272-1/3

RELEASED
2016-03-07

APPROVED

DESIGN	CC	DART AEROSPACE USA, INC EUGENE, OREGON, USA	
DRAWN	CC		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5235	SHEET 4 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	AW139 CABIN STEP	NTS
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